

DART AEROSPACE LTD	Work Order:	21384
Description: Rebuild Doulder Assy	Part Number:	D31S1-041
Dwg: D31S1-041	Qty:	(6)

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	U	04-09-15	6
2	GA	cut blank batch m148805 met'l			
3	GA	mark out at size D31S1-1 D31S1-3 as per dwg D31S1	JM	04-09-13	6
4	GA	Alodine	JM	04-09-13	6
5	GA	Make the Holes for rivets and - alburos nut plate touch up of alodine for each holes	JM	04-09-15	6
6	GA	dustal rivet ms 20426 ad 3-3 QTY 6 - MS 20426 AD3-3 M 7681 dustal nut plate QTY 2 MS 21059 208 M 9032 QTY 4 MS 20426 AD 3-4 M 9748	JM	04-09-20	6
7	QC	INSPECT To step 6	12	04-09-20	6
8	ST	Put in Stock	JM	04-09-20	6
9	AC	25.47 sac 04/09/21 (6)			
	Rev	Date	Change	Revised By	Approved
A			New issue		

10 DC Inspect Level 21
Close w/o

6 04.09.21 6

Job Costing Report

Dart Aerospace Ltd.
HawkesburyAug 23, 2004
09:51 am

Work Order No : 0021384
 Project Name : D3151-041
 Project For : WK440
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3151-041
 Description : Doubler Assembly
 Manufactured : No
 Amount Req'd : *6*
 Amount Done : *0*
 Start Date : 08-23-04
 Est Finish Date : 09-21-04
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

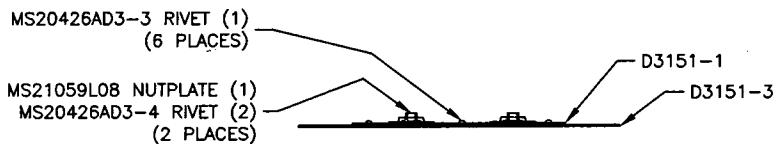
Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00	0.00	0.00
Total Cost :	0.00	0.00	0.00	0.00	0.00
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

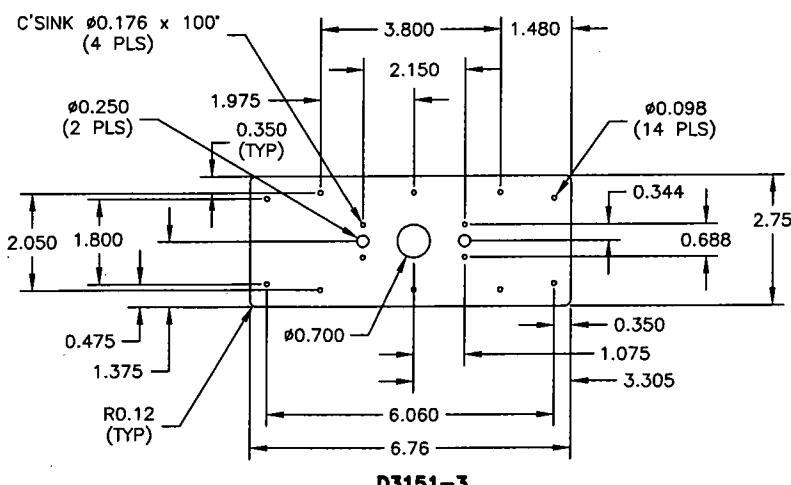
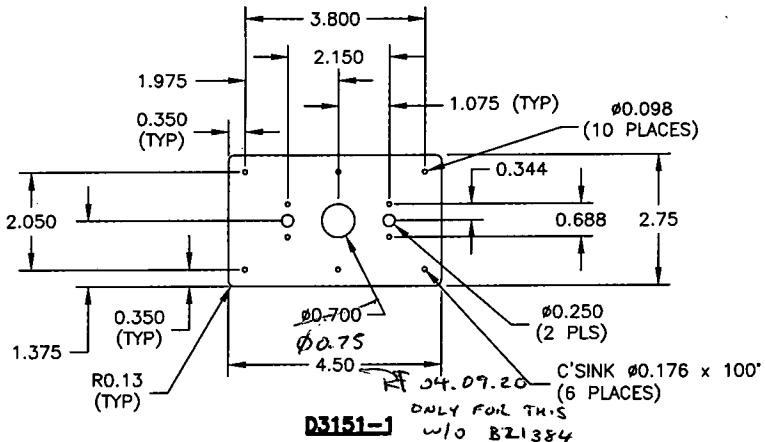
	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

B 21384

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3151	SHEET 1 OF 1
DATE		TITLE	SCALE
04.09.08		DOUBLER ASSEMBLY	1:4
A	02.04.23	NEW ISSUE	
B	04.09.08	RE-DESIGN	



D3151-041 DOUBLER ASSEMBLY
REPLACES PREMIER P/N B30-23000-173/-174



NOTES

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.040" THICK (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D3151-041 USING FINE POINT PERMANENT INK MARKER

PRELIMINARY ISSUE